

with a previous operation. After the work is inserted in the jig, it is clamped by closing the cover C, which is hinged at one end and has a cam-shaped clamping latch 1) at the other, that engages a pin E in the jig body. The four holes are drilled by passing the drill through the guide bushings B in the cover.

Another jig of the same kind, but designed for drilling a hole having two diameters through the center of a steel ball,

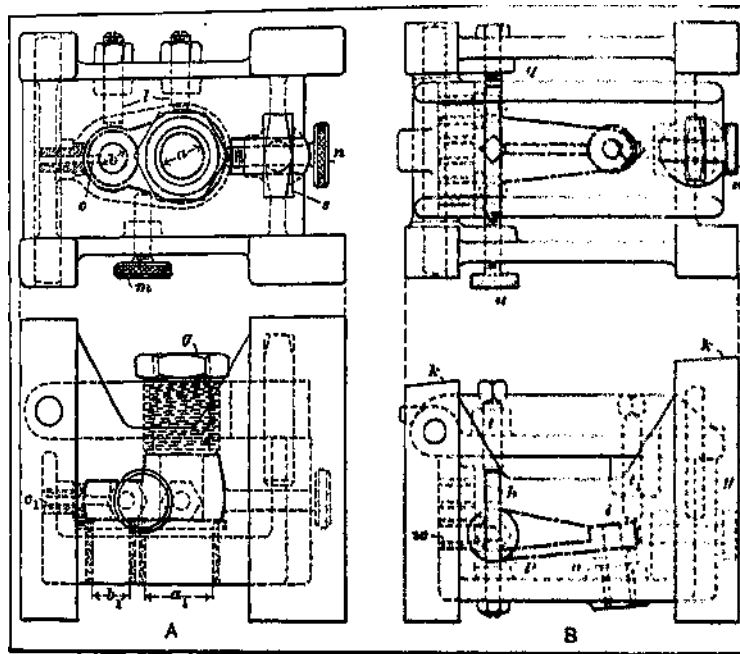


Fig. 4. Box Jigs for Drilling  
Parts shown by Heavy Dot-anti-  
dft» h time §

is shown in Fig. 3. The work, which is shown enlarged in A, is inserted while the cover is thrown back EH indicate\*! b> the dotted lines. The cover is then dosed and tightened by tin\* cam-latch D, and the large

part of the hole is drilled  
with  
the-jig in the position  
shown. The jig is then  
turned over and  
a smaller drill of the  
correct size is fed through  
guide bushing  
*B* on the opposite side. The  
depth of the  
hole could be  
gaged for each ball drilled,  
by feeding the drill spindle  
down to  
a certain position as shown  
by graduation or other  
but